

Date: Monday, 4/30/2007 7:22:12 AM
 User: Kim Johnston

Process Sheet

| | |
|---|------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : WEARPLATE |
| Job Number : 32097 | |
| Estimate Number : 10298 | |
| P.O. Number : N/A | Part Number : D25773 |
| This Issue : 4/30/2007 S.O. No. : N/A | Drawing Number : D2577 REV E |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A | Drawing Revision : E |
| Previous Run : 30551 | Material : N/A |
| | Due Date : 5/20/2007 |
| Written By : _____ | Qty: 30 Um: Each |
| Checked & Approved By : <u>07.04.30</u> | |
| Comment : Est. F 02.09.24 Re-format; Incorporated D2577-101/-13 K | |
| J/RF | |
| Est. C 06.07.21 waterjet EC | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|------------|-------------------------|
| 1.0 | M1010S16GA | 1010/1025/A21/6aA SHEET |
|-----|------------|-------------------------|



Comment: Qty.: 0.9240 sf(s)/Unit Total : 27.7200 sf(s)

1010/1025/A21/6aA SHEET 0.063 thick

Batch: ml 07 05 16

(30)

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut D2577-101 as per Dwg D2577

Dwg Rev: EProg Rev: E

ml 07 05 16

(30)

2-Deburr if necessary

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



ml 07 05 16



(30)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



ml 07 05 22 (30)



Comment: SECOND CHECK

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

John 07/05/23

(30)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/06/06
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 4/30/2007 7:22:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 32097

Part Number: D25773

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake as per Dwg D2577 using DT8155 and DT8179

2-Identify as D2577-3

SB - 07/05/25 (30)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

LAOS-29 (30)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description
A/R 7560 Hardcoat Rod

Batch

M10/1221

FC 07/06/01 30

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/06/04 (30)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 10/1601

BR/EX. 07-06-04 (30)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 07/06/05 (30X)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP-18

M-1 07/06/05 (30X)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/05 (30)

Job Completion



W. J. Dobb

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

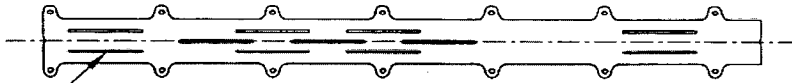
NOTE: Date & initial all entries



RELEASED
00.09.22

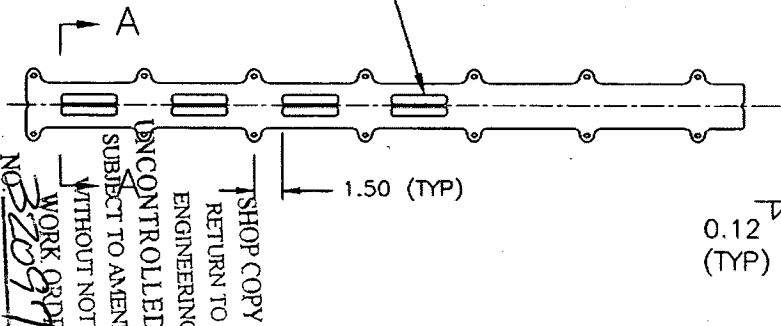
| DESIGN | DRAWN BY | DART AEROSPACE LTD |
|----------|----------|--|
| CHECKED | APPROVED | HAWKESBURY, ONTARIO, CANADA |
| DATE | TITLE | REV. E |
| 00.09.22 | WEARSHOE | SHEET 1 OF 5 |
| A | 96.09.16 | NEW ISSUE |
| B | 96.12.04 | ADD HARDCOAT WELDS |
| C | 97.05.30 | CHANGE HOLES TO OBOUNDS |
| D | 98.08.17 | CORRECTED DIMENSIONS ON -1 & -3 |
| E | 00.09.22 | ADD D2577-101/-11/-13 INCORPORATE DE09176 |

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

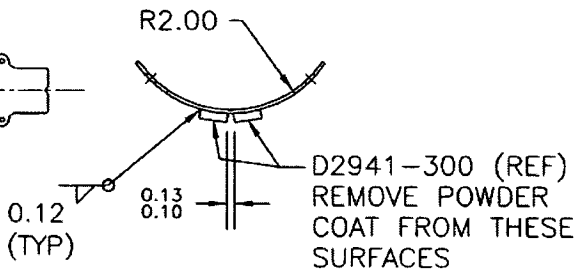


D2577-1 & D2577-3 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300
SHWAYDER WEAPADS
(8 PLACES)



SECTION A-A
SCALE 1:5



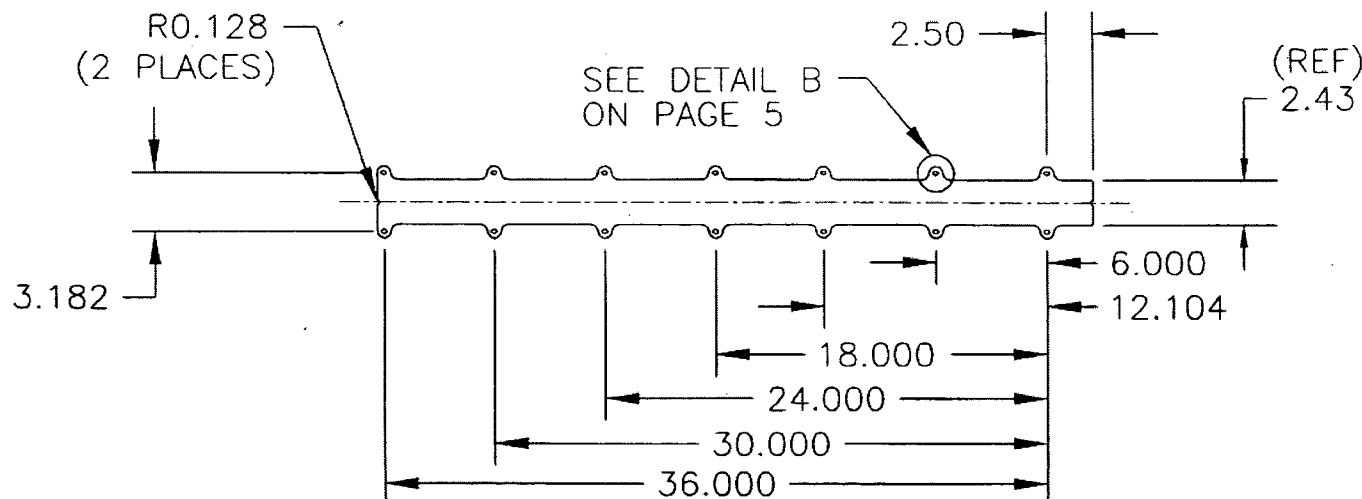
D2577-21 & D2577-23 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



| DESIGN | DRAWN BY | DRAWING NO. | REV. E |
|-------------------------------|--------------------------------|-------------------|---------------|
| <i>[Signature]</i> | <i>GP</i> | D2577 | SHEET 2 OF 5 |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | TITLE WEARSHOE | SCALE 1:10 |
| DATE 00.09.22 | | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

RELEASED
00.09.26 #



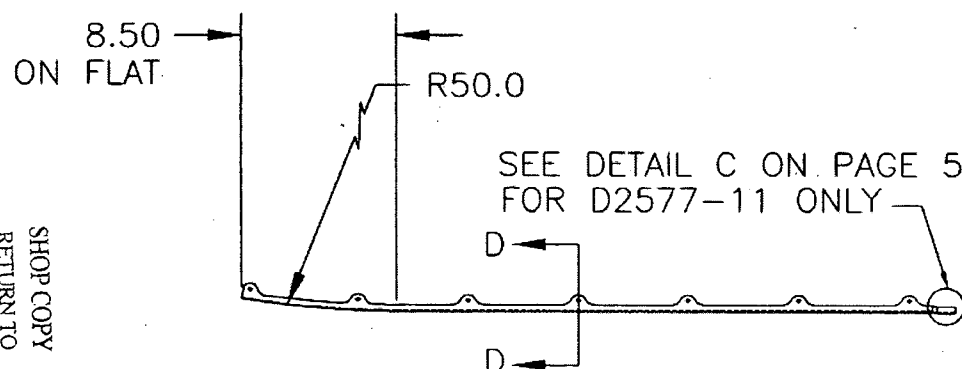
D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER
NO. 32097
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

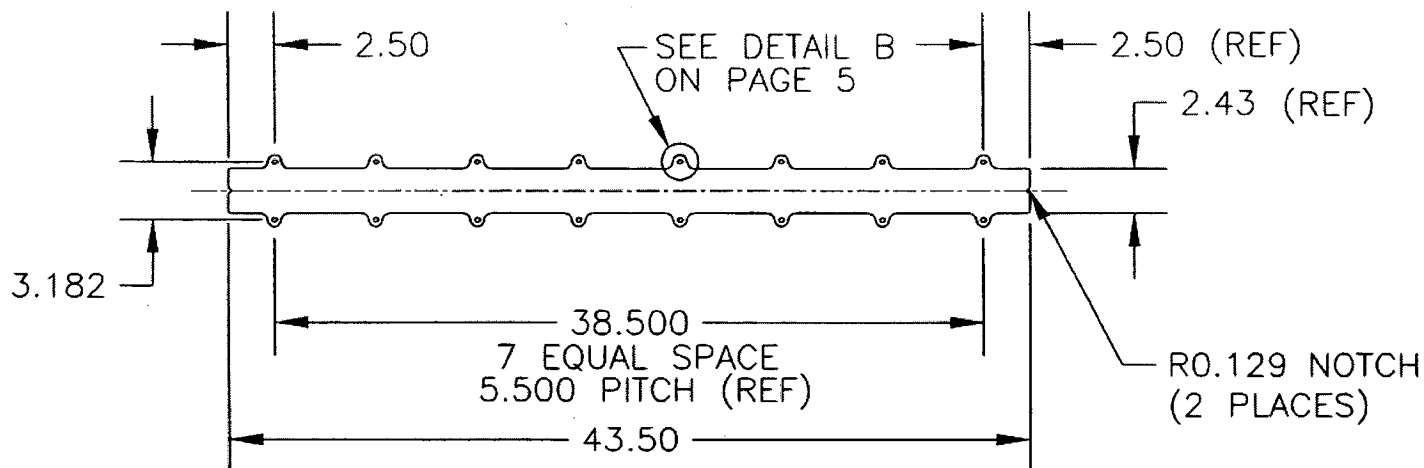
DART



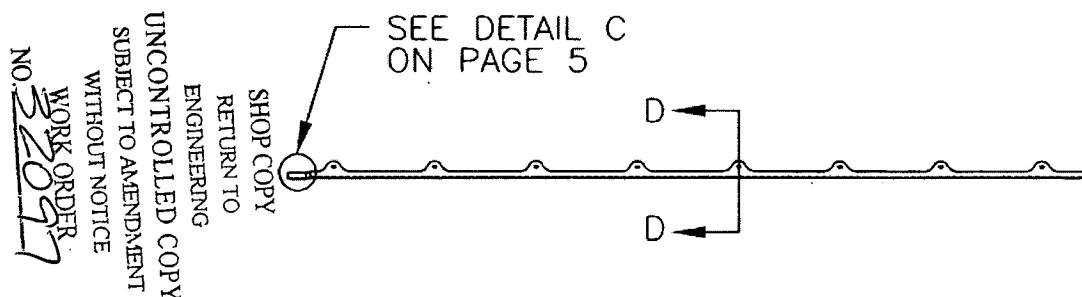
| | | | | |
|---------|--------------------|-------------|--------------------|---|
| DESIGN | <i>[Signature]</i> | DRAWN BY | <i>[Signature]</i> | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA |
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | |
| DATE | 00.09.22 | DRAWING NO. | D2577 | |
| | | TITLE | WEARSHOE | |
| | | REV. E | SHEET 3 OF 5 | |
| | | SCALE | 1:10 | |

RELEASED
00.09.26

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

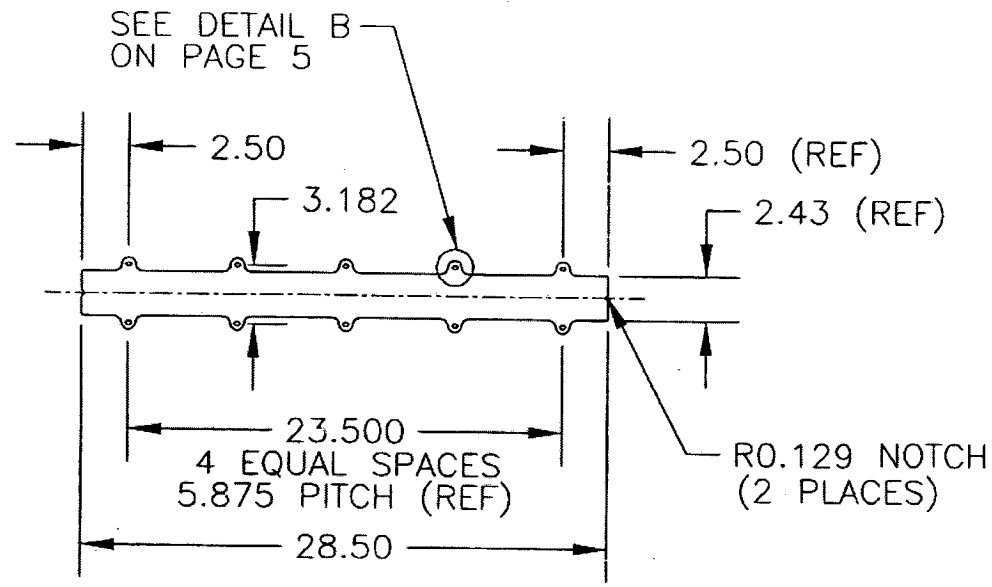
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



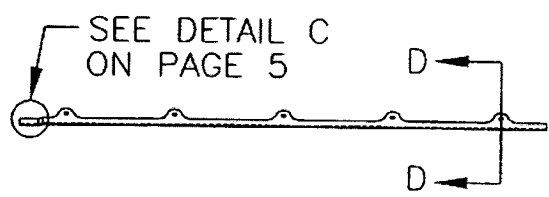
| | | | |
|----------|----------|---|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. E |
| DATE | | D2577 | SHEET 4 OF 5 |
| 00.09.22 | | TITLE | SCALE |
| | | WEARSHOE | 1:10 |

RELEASED
00.09.26

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32097

D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

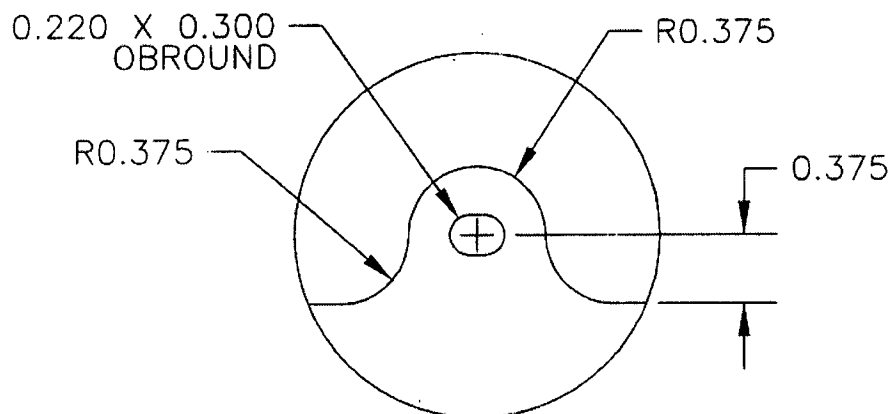
Copyright © 1996 by DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



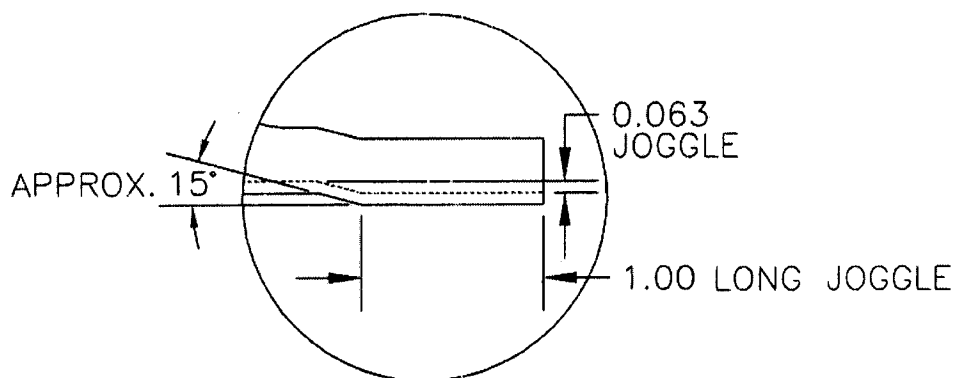
| | | | |
|------------------|----------------|---|------------------------|
| DESIGN # | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D2577 | REV. E SHEET 5 OF 5 |
| DATE 00.09.22 | | TITLE WEARSHOE | SCALE 1:10 |

RELEASED
00.09.26

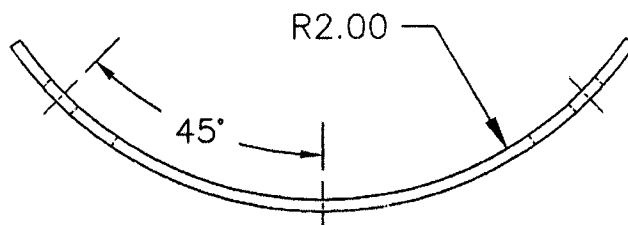
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32097

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

| | | |
|--|--|----------------------|
| DART AEROSPACE LTD | | Work Order: 32097 |
| Description: Boopaw Wearplate | | Part Number: D2577-3 |
| Inspection Dwg: D2577 Rev: E | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet | Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|------------------|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| A | 3.182 | +/- 0.010 | 3.182 | ✓ | | vern | |
| B | 2.43 | +/- 0.030 | 2.437 | ✓ | | vern | |
| C | 0.220x0.300 | +/- 0.010 | 0.219x0.300 | ✓ | | vern | |
| D | 36.000 | +/- 0.010 | 36.000 | ✓ | | Measuring tape | |
| E | 30.000 | +/- 0.010 | 30.000 | ✓ | | Measuring tape | |
| F | | | | | | | |
| G | | | | | | | |
| H | | | | | | | |
| I | | | | | | | |
| J | | | | | | | |
| K | | | | | | | |
| L | | | | | | | |
| M | | | | | | | |
| N | | | | | | | |
| O | | | | | | | |
| P | | | | | | | |
| Q | | | | | | | |
| R | | | | | | | |
| S | | | | | | | |
| T | | | | | | | |
| U | | | | | | | |
| V | | | | | | | |
| W | | | | | | | |
| X | | | | | | | |
| Y | | | | | | | |

| | | | |
|--------------------------|--------------------------------|---------------------|-----|
| Measured by: <i>M. M</i> | Audited by: <i>[Signature]</i> | Prototype Approval: | N/A |
| Date: 07.05.16 | Date: 07.05.16 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 04.01.09 | New Issue | KJ/RF | |

[Signature]